

# Work Order ID 52526

September 29, 2009 11:31:42 AM



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Item ID:	D2432	Accept		Setup	Start	
Revision ID:	F3				Stop	
Item Name:	206 (24") Bearpaw					
Start Date:	29/09/2009	Start Qty:	24.00	Cust Item ID:		
Required Date:	16/10/2009	Req'd Qty:	24.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-29	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								

BG 10-10

130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								

DI 09/10/18 / M.A 09/10/20

24 0

140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

DI 09/10/18

24 0

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Item ID: D2432

Accept



Setup Start



Revision ID: F3

Stop



Item Name: 206 (24") Bearpaw

Start Date: 29/09/2009 Start Qty: 24.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MWF  
09/10/21

24 0

151

Identify as per dwg & Stock Location: PPR

0.00



Packaging

Memo

0.00

Packaging

52525

PC 9/11/23 (29)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MWF  
09-10-23

# Picklist Print

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Work Order ID: 52526

Parent Item: D2432RevF3

Parent Item Name: 206 (24") Bearpaw



Start Date: 29/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	523.2231	88.8000			
UHMW 1" Black												189-10-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	446.5752	
112186	126.5752	
112514	200	
112681	120	
Main Warehouse		
ST	76.6479	
108762	11	
109186	5	
110520	8	
110721	10.5602	
111354	42.0877	

112 514 x 10 = 59.2  
112 681 x 8 = 29.6

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52526
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063x45°	✓			
B	5.500	+/-0.030	5.504	✓			
C	0.200	+/-0.030	0.200	✓			
D	0.25 x 45°	+/-0.030	0.25x45°	✓			
E	R0.250	+/-0.030	0.250	✓			
F	0.250	+/-0.010	0.250	✓			
G	0.625	+/-0.030	0.630	✓			
H	0.375	+/-0.010	0.376	✓			
I	0.950	+0.030/0.010	0.956	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.128	✓			
L	3.28	+/-0.030	2.286	✓			
M	Ø0.260	+0.005/-0.000	0.260	✓			
N	Ø0.93	+/-0.030	0.923	✓			
O	0.30	+0.030/-0.000	0.320	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	1.994	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	0.380	✓			

<b>Measured by:</b> DJT	<b>Audited by:</b> mmf	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/10/18	<b>Date:</b> 09/10/17	<b>Date:</b>	

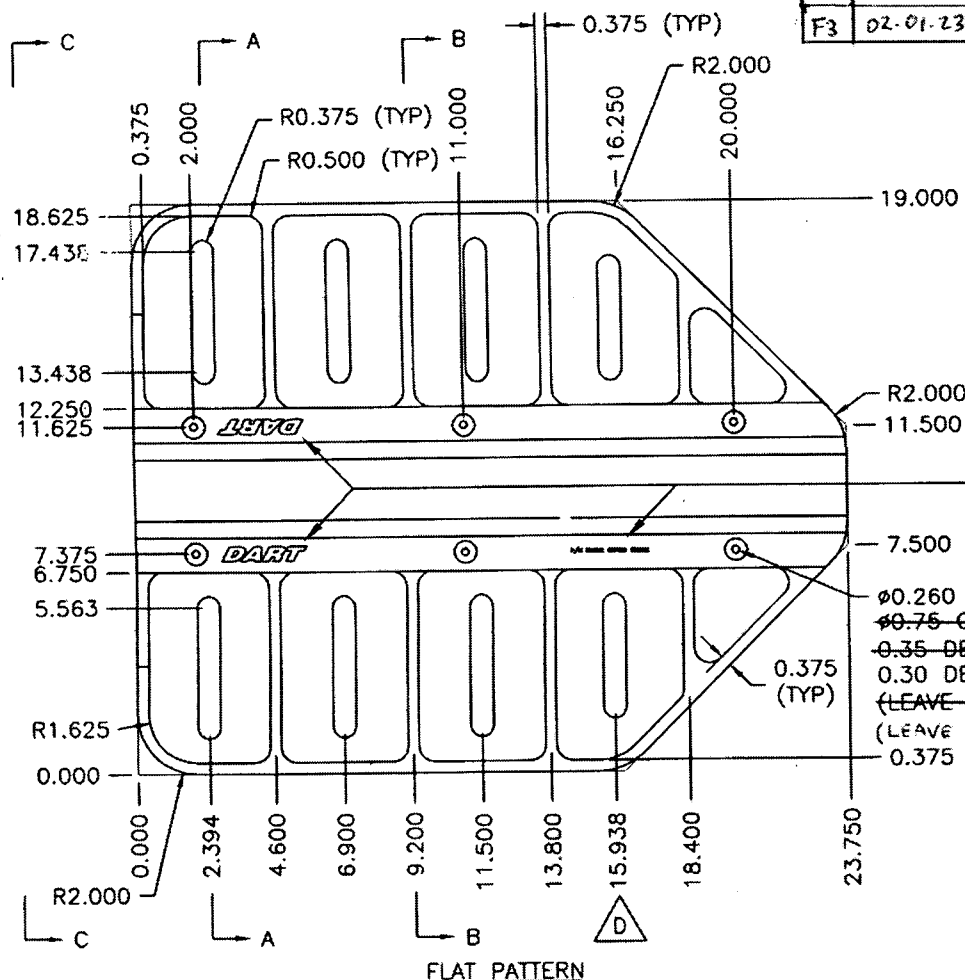
Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	PF



RELEASED  
98.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 <del>RF</del>
F3	02.01.23	CLARIFY CORE DIMS <del>RF</del>

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



0.260 (TYP)  
0.75 C'BORE Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375



EFFECTIVE  
9143

DEOS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
KE	KE		
CHECKED	APPROVED	DRAWING NO.	REV. F
MM	MM	D2432	SHEET 1 OF 2
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW



BEND AFTER MACHINING  
(D2432B ONLY)

0.950 (REF)

13.750

1.000

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WITHOUT NOTICE  
WORK ORDER  
NO. 52522

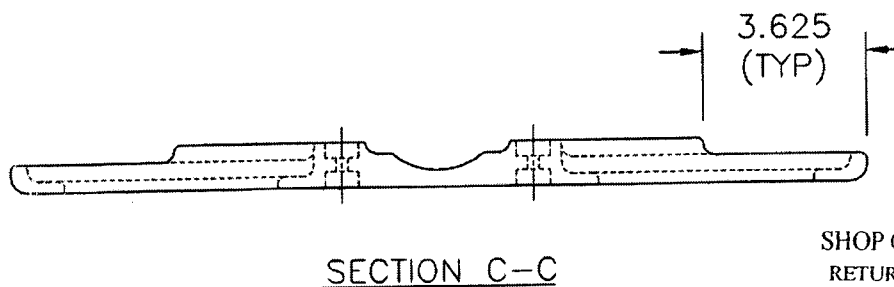
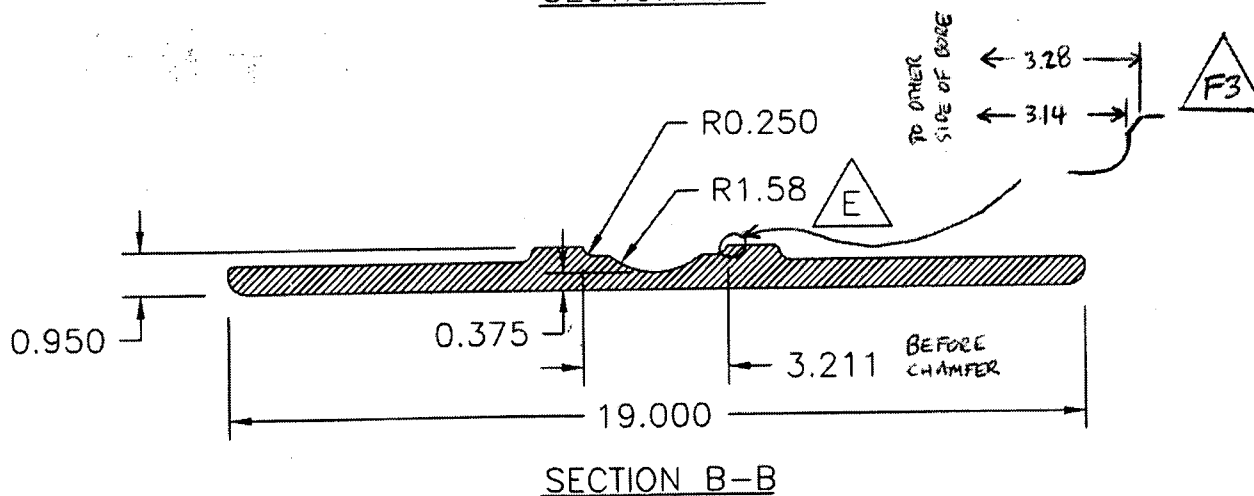
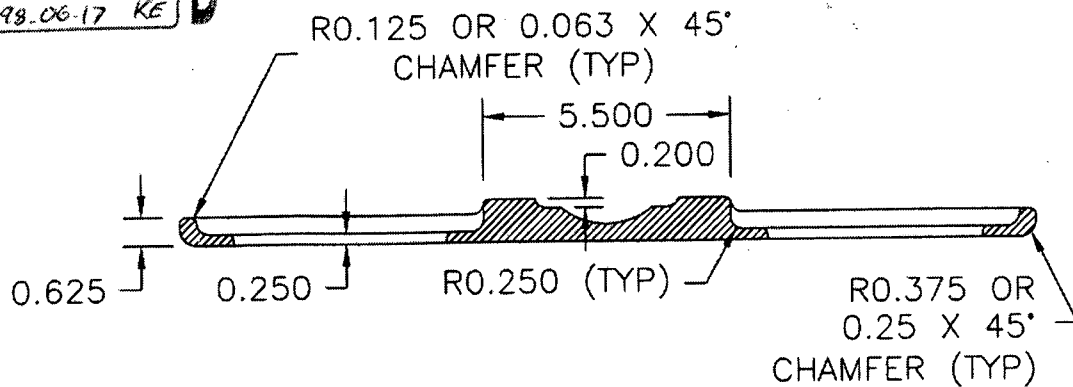
03-9-29

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98-06-17 KE



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